

Date: Tuesday, 22/05/2007 3:16:11 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 350 SKIDTUBE EXTRUSION (BENT)	
Job Number	: 32448	Part Number	: D26003BENT	
Estimate Number	: 10997	Drawing Number	: D2600 D1/D2750 D	
P.O. Number	: N/A	Project Number	: N/A	
This Issue	: 22/05/2007	Type	: MACHINED PARTS	
Prsht Rev.	: NC	Drawing Revision	: D1/D	
First Issue	: N/A	Material	: N/A	
Previous Run	: 30666	Due Date	: 31/05/2007	
Written By				
Checked & Approved By				
Comment	: Est. B02.11.28 Reformat KJ			
Qty: <u>20</u> Um: <u>SD</u> Each				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D26003120	Extrusion Round 3" 350	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) Extrusion Bent Pick: Qty Part Number Description Batch <u>B 23201</u> <u>7-S-23</u> 1 D2600-3 Extrusion			
2.0	BENDING	BENDING MACHINE	
Comment: BENDING MACHINE Deburr one end of extrusion Drill #30 pilot holes using DT8689 Open holes to 5/16" and deburr Bend using CNC bending machine as per program 2750.C and Folio FT003. Use 5/16 locator pin on buggy "A". Check fit to Jig DT8150 <u>R 7-5-23</u> <u>EL 7-5-23</u>			
3.0	QC5	INSPECT WORK TO CURRENT STEP	
Comment: INSPECT WORK TO CURRENT STEP Inspect work to Step 6 Ensure fit to Jig DT8150 <u>DP 7-5-31</u> <u>SI</u>			
4.0	PACKAGING 1	PACKAGING RESOURCE #1	
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>LG</u> <u>DP 7-5-31</u> <u>SI</u>			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/06/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 22/05/2007 3:16:11 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE EXTRUSION (BENT)

Job Number: 32448

Part Number: D26003BENT

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC21

FINAL INSPECTION/W/O RELEASE



(S)

Comment: FINAL INSPECTION/W/O RELEASE

Do 7/06/01

Job Completion



C 207/05/131

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D2750
		REV. D SHEET 1 OF 5
DATE 06.01.05	TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS
A	98.04.16	NEW ISSUE
B	98.09.01	CHANGE MS24694-S293 TO AN8-16A
C	98.11.18	ADD D2750-3/D2750-4 INCORPORATE D2738 AND D2740
D	06.01.05	ADD HOLES AND SPACERS FOR APICAL FLOATS INCORPORATE DEO 9133/9157

RELEASED
*06.02.07 PH***UNDER REVIEW***07.02.05 CB**add gaskets
change to SS wear plates*

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D2750-041	SKIDTUBE ASSEMBLY, LH
	X			D2750-042	SKIDTUBE ASSEMBLY, RH
		X		D2750-043	SKIDTUBE ASSEMBLY, LH
			X	D2750-044	SKIDTUBE ASSEMBLY, RH
5	5	5	5	D2648-3	WEARPAD
1	1	1	1	D2656-13	WEARSHOE
1	1	1	1	D2656-35	WEARSHOE
1	1	1	1	D2746	WEARSHOE
1	1	1	1	D2739	WEB
1	1	1	1	D2741	BLADE
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
38	38	38	38	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN3C7A	BOLT
4	4	4	4	AN6C44A	BOLT
2	2	2	2	AN8C21A	BOLT
1	1	1	1	AN8C35A	BOLT
46	46	46	46	AN960C10L	WASHER
4	4	4	4	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
3	3	3	3	MS21083C8	NUT
42	42	42	42	NAS1330S3KB166	INSERT
46	46	46	46	NAS1515H3L	WASHER
12	12	12	12	NAS1515H8L	WASHER

*PH
324M6*

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DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>TH</i>	APPROVED <i>TH</i>	DRAWING NO. D2750	REV. D SHEET 2 OF 5
DATE 06.01.05		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS

UNDER REVIEW

07.02.05 (b)
SS wearplates

RELEASED
06.02.07

GENERAL NOTES:

1. ALL DIMENSIONS ARE IN INCHES
2. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
3. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
4. DAMAGE TOLERANCE ON BENDING:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.15 ± 0.030 IN THE BENT PORTION OF THE TUBE.
5. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS E-E, F-F, AND R-R.
6. WELDING TO BE DONE PER DART QSI 004.
7. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
8. FINISH:
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
9. INSTALL NAS1330S3KB166 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4 AND 5. DRILL 'E' SIZE HOLES ($\varnothing 0.250$ - $\varnothing 0.257$) FOR WEARSHOE INSERTS. C'SINK $\varnothing 0.391$ X 100° AND INSTALL INSERTS
10. D3488-041 (OR D3488-042) BLADE FITTING AND AN3-5A/AN3-7A WEARSHOE SCREWS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.
11. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
12. APPLY A LAYER OF SIKAFLEX -241/-291 ADHESIVE BETWEEN THE BOTTOM OF THE SKIDTUBE ASSEMBLY AND THE WEARPLATES

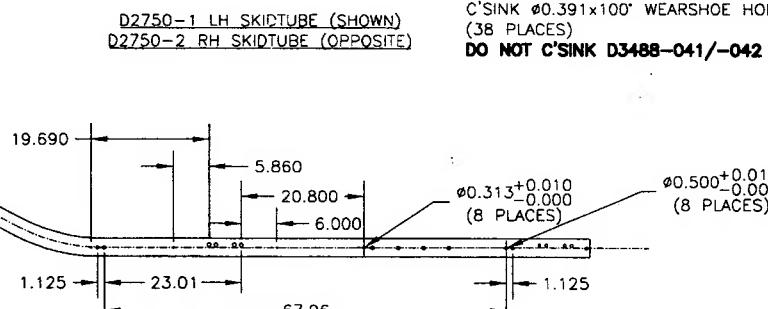
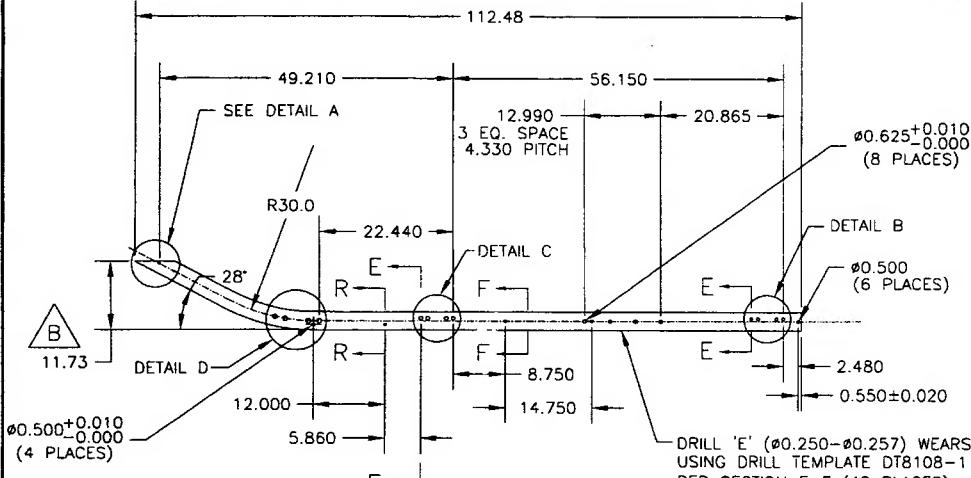
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UNDER REVIEW

07-02-05 18

SS wear plates

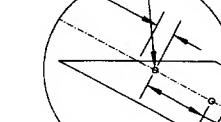


D2750-3 LH SKIDTUBE (SHOWN)
D2750-4 RH SKIDTUBE (OPPOSITE)
D2750-3/-4 AND D2750-1/-2 HAVE THE SAME SADDLE AND GROUND HANDLING HOLES

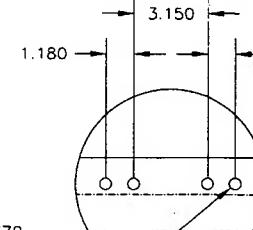
DRILL 'E' (Ø0.250-Ø0.257)

C'SINK Ø0.291X100'
(4 PLACES)

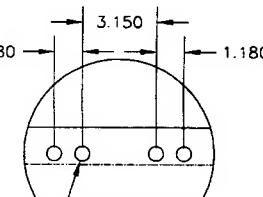
0.83



DETAIL A

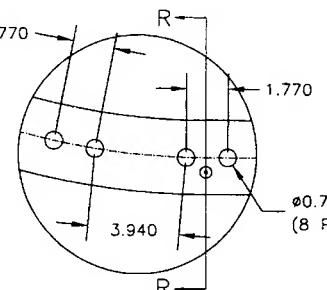


DETAIL B



DETAIL C

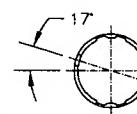
Ø0.500^{+0.010}_{-0.000}
(8 PLACES)



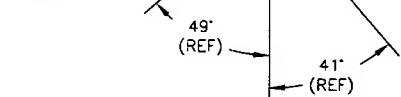
DETAIL D
(ALL DIMENSIONS ARE STRAIGHT LINE DIMENSIONS)

(FROM WEARSHOE CL TO SKIDTUBE CL)

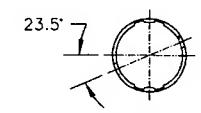
0.110



SECTION E-E



SECTION F-F



SECTION R-R

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PH

DRAWN BY

PH

DART

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

REV. D

CHECKED

#

APPROVED

#

DRAWING NO.

D2750

SHEET 3 OF 5

DATE

06.01.05

TITLE

SCALE

350 SKIDTUBE ASSEMBLY

1:20

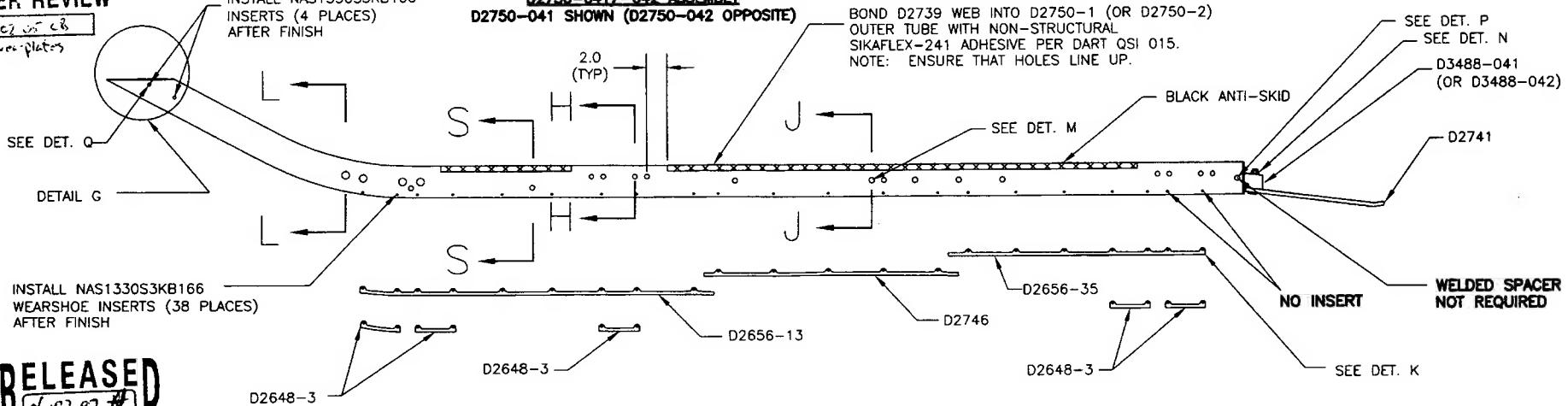
UNDER REVIEW

C7-C7 JET C8
44 wear plates

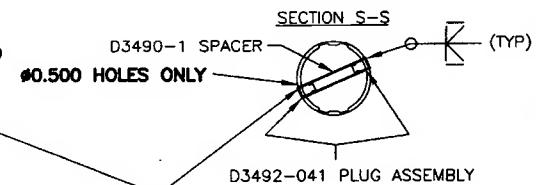
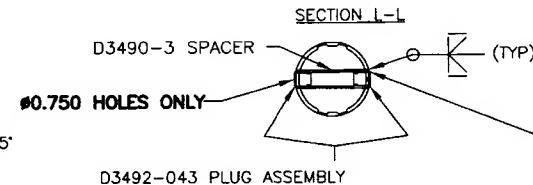
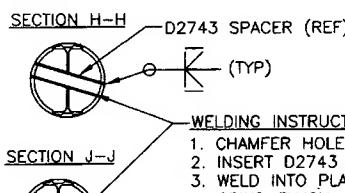
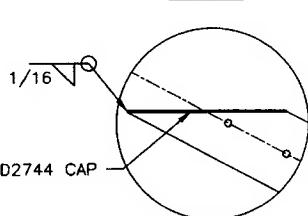
INSTALL NAS1330S3KB166
INSERTS (4 PLACES)
AFTER FINISH

D2750-041/-042 ASSEMBLY
D2750-041 SHOWN (D2750-042 OPPOSITE)

BOND D2739 WEB INTO D2750-1 (OR D2750-2)
OUTER TUBE WITH NON-STRUCTURAL
SIKAFLEX-241 ADHESIVE PER DART QSI 015.
NOTE: ENSURE THAT HOLES LINE UP.



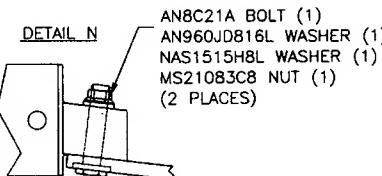
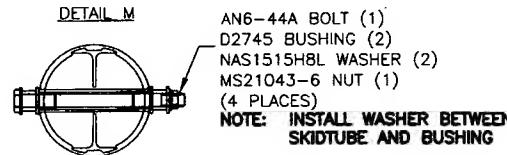
DETAIL G



DETAIL K
USE AN3C7A BOLTS FOR INSTALLING AFT D2648-3 WEARPAD (4 PLACES)



AN3C5A BOLT (1)
AN960JD10L WASHER (1)
NAS1515H3L WASHER (1)
(38 PLACES)



DETAIL P

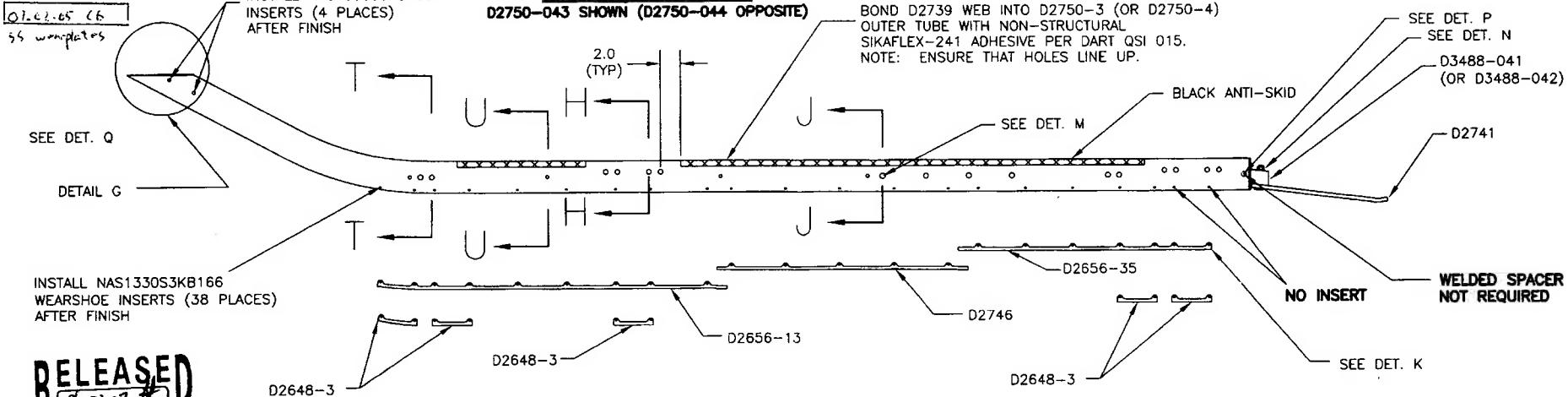
AN8C35A BOLT (1)
AN960C816L WASHER (2)
NAS1515H8L WASHER (2)
MS21083C8 NUT (1)

DETAIL Q

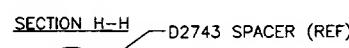
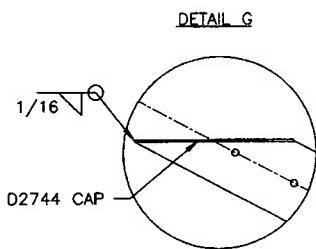
AN3C6A BOLT (1)
AN960C10L WASHER (1)
NAS1515H3L WASHER (1)
(4 PLACES)

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CHECKED APPRVED			DRAWING NO. D2750	REV. 0 SHEET 4 OF 5
DATE 06.01.05			TITLE 350 SKIDTUBE ASSEMBLY	SCALE

UNDER REVIEW



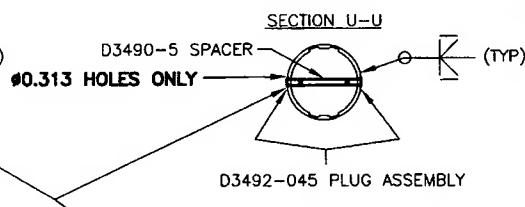
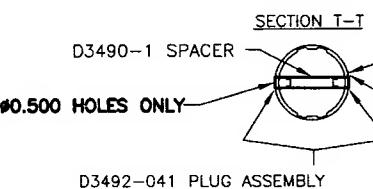
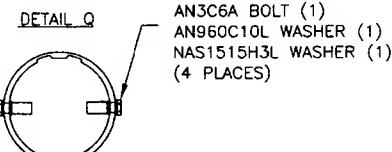
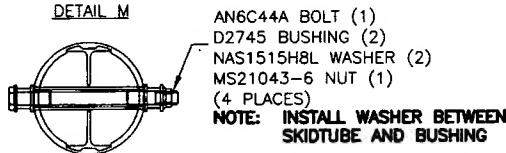
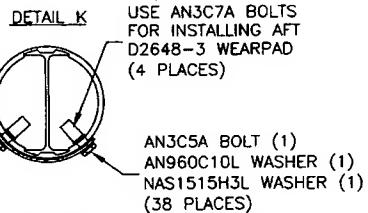
RELEASED
06.02.07.11



WELDING INSTRUCTIONS

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2743 SPACER
3. WELD INTO PLACE
4. GRIND FLUSH
5. DRILL OUT SPACER TO Ø0.484
6. SPOT FACE Ø0.750 (SECTION J-J ONLY)

SECTION J-J



WELDING INSTRUCTIONS

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D3490-5 SPACER (4 PLACES) INTO
Ø0.313 HOLES OR INSERT D3490-1 SPACER (4
PLACES) INTO Ø0.500 HOLES
3. WELD INTO PLACE
4. GRIND FLUSH
5. INSERT D3492-045 PLUG ASSEMBLY (8 PLACES)
INTO D3490-5 SPACER OR INSERT D3492-041 PLUG
ASSEMBLY (8 PLACES) INTO D3490-1 SPACER ON
BOTH ENDS

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DESIGN	DRAWN BY	DART	DART AEROSPACE USA, INC. PORT HANCOCK, WA
PJ	PJ		REV. D
CHECKED	APPROVED	D2750	SHEET 5 OF 5
DATE	TITLE	06.01.05	SCALE 1:20
		350 SKIDTUBE ASSEMBLY	